

Work Order ID 53165

October 24, 2009 10:43:59 AM

Page 1

Item ID: D3785-3

Accept

Setup Start

Revision ID: *B C custom*

Item Name: Bracket

Stop

Start Date: 10/26/2009 Start Qty: 3.00

Cust Item ID:

Required Date: 10/28/2009 Req'd Qty: 3.00

Customer:

Reference:

Approvals:

Process Plan: *mf*

Date: *09-10-27*

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3785	Rev C

100

0.00



FLOW WATER JET

Waterjet

Memo

FLOW CNC Waterjet

1-Cut as per Dwg D3785 ☐ Dwg Rev: *C custom* ☐ Prog Rev: *C custom*

☐

****grain direction along 3.44"****

☐ 2- Deburr if necessary

B 9-10-27

8

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

Quality Control

0.00

ENGINEERING
APPROVAL

09/10/29

B 9-10-27

120

0.00



QC8- Inspect parts - second check

QC

Memo

Quality Control

0.00

09/10/27

48

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Page 2

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 Brake NC Brake NC	NC BRAKE Memo Bend as per Dwg D3785	0.00 0.00	SB 09/10/29			3			
						make 3 only			
							u		
140 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00	2) Serkoby				0		
150 Small Fab Small Fab Small Fab	Small Fab Memo 1-counter sink holes as per dwg D3785	0.00 0.00	M-L 09/10/29						
									(3X)

ENGINEERING
APPROVAL

09.10.29

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Page 3

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Cust Item ID:

Required Date: 10/28/2009 Req'd Qty: 3.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC5- Inspect part completeness to step on W/O

0.00



2) 50% k/b 29

QC

Memo

0.00

(X3)

Quality Control

170

Chemical Conversion Coat per QSI005 4.1

0.00



LF 09-10-29

HandFinish

Memo

0.00

(3)

Hand Finishing

180

QC3- Inspect Part Finish

0.00



JH 09/10/29

QC

Memo

0.00

(X3)

6

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Cust Item ID:

Required Date: 10/28/2009 Req'd Qty: 3.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3	0.00							
	<u>M109091</u>								
Powdercoat	Memo	0.00							
Powder Coating	START TIME: <u>11:00AM</u> FINISH TIME: <u>11:30AM</u> OVEN TEMPERATURE: <u>320°F</u>								
200	QC3- Inspect Part Finish	0.00							
QC	Memo	0.00							
Quality Control									
210	Identify as per dwg & Stock Location: <u>GA</u>	0.00							
Packaging	Memo	0.00							
Packaging									

⇒ JU 09/10/29

(X3) 0

BK 09-10-29

(3)

80 09/10/20

(2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

220

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

SCRAP
632-1653

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

October 24, 2009 10:43:59 AM

Page 1

Work Order ID: 53165



Parent Item: D3785-3RevB



Parent Item Name: Bracket



Start Date: 10/26/2009

Required Date: 10/28/2009

Comments:

Start Qty: 3.00

Required Qty: 3.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6S.080  6061-T6 .080 Sheet		Purchased	No				sf	284.9347	0.8100	3.000		
												189-10-27

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

284.9347

107904

0.02

110254

2.5

110630

38.0926

112040

0.0437

112141

33

112512

19.2784

112763

192

112512

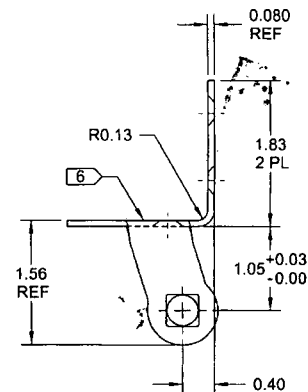
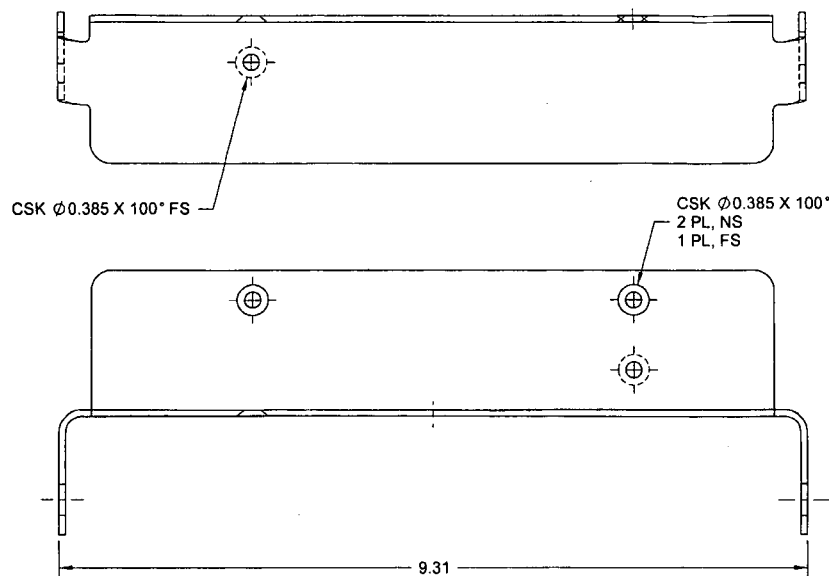
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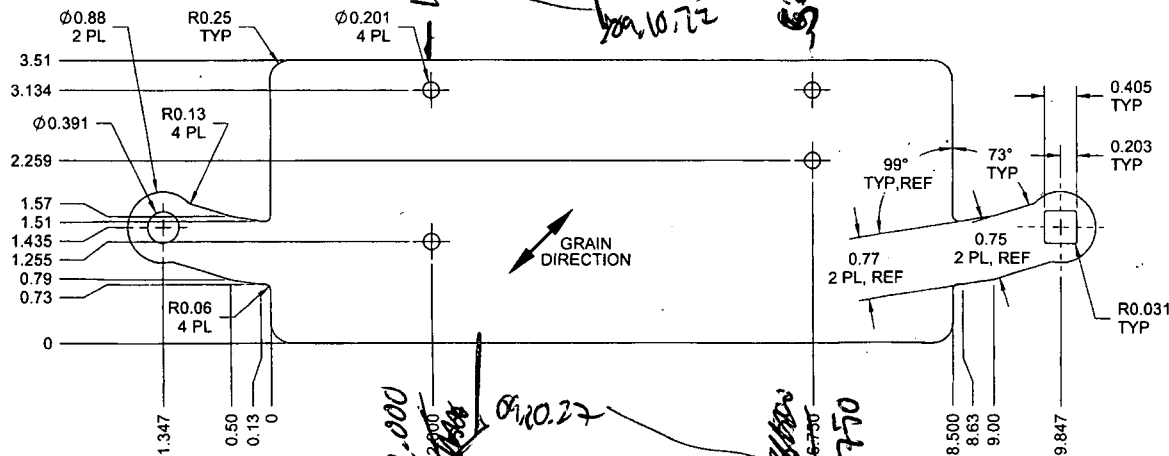
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D3785-3 BRACKET
MAKE FROM D3785-3F



D3785-3F FLAT PATTERN 1

D3785-3 NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.080 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
REF. DART SPEC. M6061T6S.080
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART
QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3785-3" USING FINE
POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.25 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3785	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		BRACKET	NTS
DATE	09.05.07	COPYRIGHT © 2008 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

RELEASED
09/07/07

0.1955

W/O:		WORK ORDER CHANGES					
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Melanie Fauteux

From: Marc Bellavance [mbellavance@dartaero.com]
Sent: October 22, 2009 3:11 PM
To: 'Jason Murdoch'; 'Melanie Fauteux'
Cc: 'Mike Petsche'
Subject: NCR required for D3741 Rev. D
Attachments: D3785-3F Rev.C (CUSTOM).dxf

Importance: High

Jason,

As per our recent conversation about parts for the D412-761-049 Armrest, hole location is wrong on one of the part and engineering requires an NCR to correct the drawing.

The drawing in question is D3781 Rev. D on which P/N D3781-1 Supporting Plate is defined (sheet 4). The hole location for DIA 0.201" should be revised as follows:

- 1) Change existing 1.500 dimension (zone C7-4) to 2.000 and to match D3785-3 Bracket;
- 2) Change existing 4.000 dimension (zone C6-4) to 4.750 and to match D3785-3 Bracket.

In the mean time, I don't see a problem with production issuing a custom work order for the manufacturing of quantity (3) D3785-3 Bracket to match the quantity (3) D3781-041 Lateral Cushion Assembly that we have in stock as it would prove to be a costly alternative to scrap them. Your NCR should document this.

Melanie,

The DXF file for your custom work order is attached to this email.

Please reference NCR number and see me for sign offs.

Thanks,

REFERENCE ONLY

Marc Bellavance
Mechanical Designer/Technical Support

DART aerospace Ltd.

Tel: 613-632-5200 Ext. 240

Fax: 613-632-9311

E-mail: mbellavance@dartaero.com

Web: www.dartaero.com



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